

Date:  
User:Monday, 7/9/2007 11:44:18 AM  
Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: RESTRICTOR ELBOW
Job Number	: 33340		
Estimate Number	: 10927		
P.O. Number	: <i>N/A</i>	Part Number	: D2005011
This Issue	: 7/9/2007	S.O. No.	: <i>N/A</i>
Prsht Rev.	: <i>NC</i>	Drawing Number	: D2005 REV C
First Issue	: <i>N/A</i>	Project Number	: <i>N/A</i>
Previous Run	: 30669	Drawing Revision	: C
		Material	: <i>N/A</i>
Written By	:	Due Date	: 7/30/2007
Checked & Approved By	: <i>07.07.09</i>	Qty:	5 Um: Each
Comment	: Est. B 99.08.24 Re-format DM/EC		

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 AN8338J Elbow,Bulkhead-M-Flare



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Elbow,Bulkhead-M-Flare

Pick:

Qty	Part Number	Description	Batch
1	AN833-8J	Elbow	

Batch

*M101331(x3) / M105052(x3)**FF 07-07-24**PTD*

2.0 D2005003 Restrictor



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Restrictor

Pick:

Qty	Part Number	Description	Batch
1	D2005-003	Restrictor	

Batch

*B19073**FF 07-07-24*

3.0 SMALL FAB 1 SMALL &amp; MEDIUM FAB RESOURCE 1



Comment: SMALL / MED FAB

Machine elbow P/N: AN833-8J per Dwg. D2005-011

Press fit D2005-003 restrictor in place as per Dwg. D2005-011

Note:(15° chamfer towards inside of fitting)

Stake restrictor in place using clean ballpeenhammer to tap down edge.

Polish smooth finish

Scribe P/N: D2005-011

*m107/07/25 (x5)**FF 07-07-24*

4.0 QC5 INSPECT WORK TO CURRENT STEP

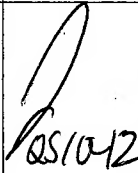
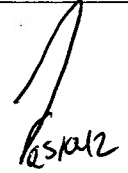
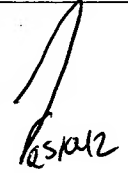



Comment: INSPECT WORK TO CURRENT STEP

*Ep 07/07/25 (x5)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: 2 Date: 07/07/24  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/07/24	3	D2005011 Drilled To deep at .587  RC operator error	 RS1042	Destroy and Replace  Replenish part B# M105057 (A)	07/07/24 FF	 07/07/24	 07/07/24	 07/07/24

NOTE: Date & initial all entries

Date: Monday, 7/9/2007 11:44:19 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: RESTRICTOR ELBOW

Job Number: 33340

Part Number: D2005011

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 577

*Corr/5/26* *(5)*

6.0

QC21

FINAL INSPECTION/W/O RELEASE



*(5)*

Comment: FINAL INSPECTION/W/O RELEASE

*120712/26*

Job Completion



*u 07.07.26*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

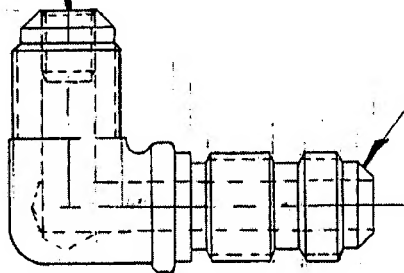


DESIGN BRADLEY	DRAWN BY BRADLEY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2005-011	REV C SHEET 1 OF 1
DATE 96.04.17		TITLE RESTRICTOR ELBOW	
C		REDRAWN 96.04.17 <i>[Signature]</i>	

RELEASED  
97/04/03 DS

DRILL 11mm DIA  
x .500 AS SHOWN.

D2005-003  
FORCE FIT AS  
SHOWN AND STAKE  
IN PLACE



ANB33-8J  
ELBOW

DETAIL OF D2005-011

SCALE 1:1

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 33340